

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015519**Date Inspected:** 20-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG 13 section**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

**Bay #14**

Caltrans QA Inspector observed four welders performed FCAW fillet weld process on stiffeners that connected to T-joint steel plate PL3384B, PL3384E, PL3240B and PL3240E of side plate #SP3092B, SP3092E, SP3060B and SP3060E with 22mm wall thick. The minimum preheat and maximum interpass temperature requirements for FCAW fillet weld are 110C degree and 230 C degree. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Caltrans QA Inspector observed a welding operator in process of semi-automatic SAW on CJP butt joint weld. The CJP weld is attached to 60mm wall thick base plate of 13AE section of east line. The weld number and plate number are BP-3033-001-002/PL3218D and PL3219D (side A). The semi-automatic saw process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Caltrans QA inspector observed a fit up groups performed fit up and SMAW tack weld process on T-joint fillet weld. The T-joint is attached to stiffeners and 25mm wall thick plate # PL3282A of 13AW section of side plates. The side plate number is SP3092A. A numerous temporary tack welds have been welded attach between side plate and stiffeners after adjusted and secured by hand jack. The fit up SMAW tack welding process were monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans QAI observation, no discrepancies were noted.

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## WELDING INSPECTION REPORT

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### Bay #16

Caltrans QA Inspector observed a welding operator in process of semi-automatic SAW on CJP butt joint weld. The CJP weld is attached to 100mm wall thick base plate of 13AW section of west line. The weld number and plate number are BP3474-001-005/PL3361C and PL3362C (side A). The semi-automatic saw process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

As notes within report above

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Pau, Wai	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford, William	QA Reviewer

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